

Work Order ID 84926

84926

Page 1

May-29-12 2:51:49 PM

Item ID: D209-669-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/05/29*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2906

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002

003 per EWN 12.5.09

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

-Open holes to 0.500" as per Dwg D2906 without cutting fluid

-Deburr and blow out all chips from

-Acid etch and Alodine tube per QSI 005 4.1

SAD 1206-20

26 12/6/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC3- Inspect Part Finish

0.00

120

QC

Memo

0.00

Quality Control

① SPO 12-06-26

130

Skidtubes

0.00

130

Skidtubes

Memo

0.00

Skidtubes

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date:

Start Time: 16:45

Fin Time: 11:00

pick:

Qty

I

P/N

D2926-3

description

Web

B/C

86263

1 / CF 12-06-26

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	BENDING MACHINE - CROSSTUBES	0.00							
140									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906								
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	-Deburr ends and remove marks from bending								
	- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

Handwritten: DP 12-6-27

Handwritten: -> CF 12-6-27

Handwritten: CF 12.7.4 / 12/07/04

Handwritten: 1 0 BE 12/07/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	Large Fab								
Skidtubes	Memo	0.00							
Skidtubes	-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Debur								
	-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Debur								
	-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Debur								

12-7-4

5/26/05

1

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Stop *NR2*

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200 Pressure Wash per QSI005 4.3

0.00

200

HandFinish

Memo

0.00

Hand Finishing

1 X 12-7-5

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

210

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:15

OVEN TEMPERATURE: 320 F

FINISH TIME: 11:45

1X 12/07/05

220

QC3- Insp Part Finish

0.00

220

QC

Memo

0.00

Quality Control

1X 12/07/06

M121841

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

230

HandFinishing

HandFinish

0.00

Hand Finishing

Memo

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 11/21/09

Sikaflex expire date: 13/03

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 11/21/09

Sikaflex expire date: 13/03

5-Wing Walk as per Dwg D2906 and QSI 005 4.4
Batch: 11/21/09

1x 6 34 11/07/09

Dart Aerospace Ltd

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Required Date: 16/07/2012 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
250		0.00							
250	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD209-669-043								
	Location: _____								
	PPP Rev: _____								
260	QC21- Final Inspection - Work Order Release	0.00							
260									
QC	Memo	0.00							
Quality Control									

Handwritten signature/initials

MLJ 12/07/23

MLJ 12/07/23

W/O:		WORK ORDER CHANGES					
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Page 1

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Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 *D4202-1* Spacer		Manufactured	No				Each	81.0000		19			
									**	19		CF 12-7-4	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG			5						
				77727			5						
				LG002			76						
				78806			6						
				79810			70						
D2500-1-190 *D2500-1-190* Ext'n -1' Beam Tube 4"		Manufactured	No			110	Each	91.0000	1	1			
									**			SAD 12-06-20	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				HALL			91						
				74777			14						
				80061			77						
D2926-3 *D2926-3* Web		Manufactured	No			110	Each	0.0000	1	1			
									**			CF 12-6-26	
D2855 *D2855* Cap		Manufactured	No			230	Each	21.0000	2	2			
									**			12/07/06	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				FP002			21						
				65519			2						
				73347			16						
				75074			3						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A Purchased No

230

Each

1,090.000

4

4

AN3-5A
Bolt

**

yl 12/07/06

Location

Loc Qty

Loc Code

ST350

1090

115371

46

117423

124

118626

31

119355

200

120187

500

121185

189

y2

AN960JD10L

NAS1149D0332J

Purchased

No

230

Each

0.0000

4

4

AN960JD10L
Washer

**

11121011

(x4) yl 12/07/06

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

ALS7-1032-130
Insert

**

(x44)

Location

Loc Qty

Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

2085

119530

73

120181

12

121444

2000

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A	Purchased	No	230	Each	1,458.000	44	44
AN3C4A						**	<u>44</u> 12/07/06
BOLT							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	1458	
120187	57	
120521	28	
120769	38	
<u>121205</u>	1000	<u>X-14</u>
121556	335	

AN960C10L	<u>NAS1149C0332</u>	Purchased	No	230	Each	0.0000	44	44
*AN960C10I *	<u>R</u>					**	<u>44</u> 11/07/06	
washer								

D2594-3		Manufactured	No	230	Each	2,418.000	14	14
D2594-3						**	<u>14</u> 11/07/06	
O-Ring, 205 Skidtube								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	2418	
65518	41	
79496	984	
79573	50	
<u>79755</u>	1343	<u>X14</u>

Dart Aerospace Ltd

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D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

D2594-1

Plug, 205 Skidtube

**

yl 12/07/06

Location

Loc Qty

Loc Code

FP001

98

73401

30

74442

18

79495

50

FP-A

213

73401

0

78590

213

D3564-9

Manufactured No

230

Each

22.0000

1

1

D3564-9

Wearshoe

**

yl 12/07/06

Location

Loc Qty

Loc Code

FG

4

76950

4

FP001

18

67590

4

69943

1

82255

13

D3564-11

Manufactured No

230

Each

8.0000

1

1

D3564-11

Wearshoe

**

yl 12/07/06

Location

Loc Qty

Loc Code

FG

4

77056

4

FP001

4

80341

4

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Shop Packet Print

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Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

230

Each

13.0000

1

1

D3564-5

Wearshoe

**

HL 12/07/06

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

11

77609

3

82254

8

XL

D3566-1

Manufactured No

230

Each

31.0000

2

2

D3566-1

Gasket

**

HL 12/07/06

Location

Loc Qty

Loc Code

FP

-22

81619

10

1384874

XL

FP002

53

68924

2

80919

3

83898

16

XL

D3566-5

Manufactured No

230

Each

21.0000

1

1

D3566-5

Gasket

**

HL 12/07/06

Location

Loc Qty

Loc Code

FP

12

82275

12

XL

FP002

9

80374

3

82274

6

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QTY	QTY	Part Number	Description
-041	-043		
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
 - ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG CW D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

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B	UPDATE DRAWING FORMAT: RE-ORGANIZE: ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.08.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D2906		REV. B SHEET 1 OF 3	
TITLE AH-1 (209) SKIDTUBE ASSEMBLY		SCALE NTS	
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

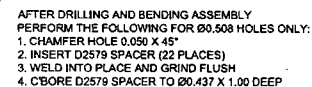
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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SECTION C-C
SCALE 1:4

DESIGN	40	DART AEROSPACE LTD	
DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P.H.	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 2 OF 3
APPROVED	21	TITLE	SCALE
DE APPR.	21	AH-1 (209) SKIDTUBE ASSEMBLY	1:24
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATELY OWNED BY DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

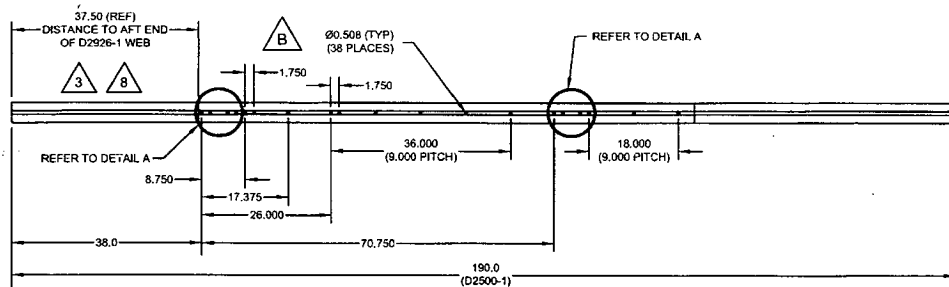
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

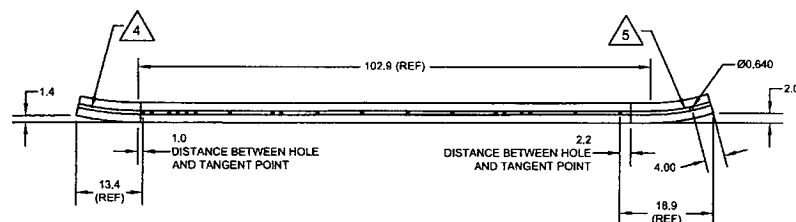
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

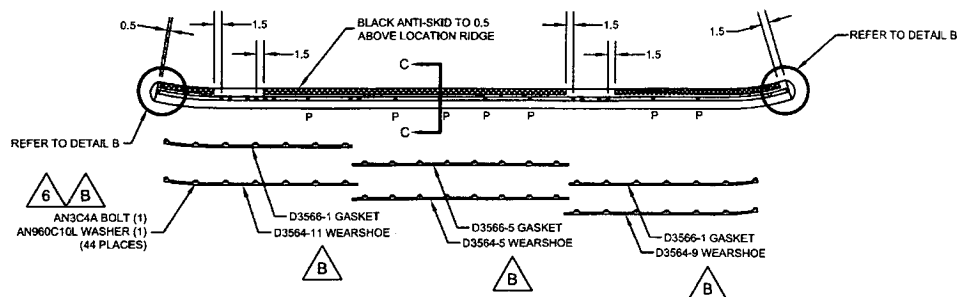
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D2906-3 DRILLING DETAIL

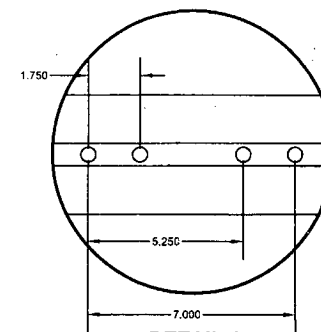


D2906-043 BENDING AND CUTTING DETAIL

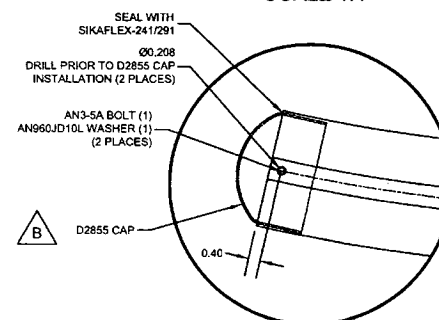


D2906-043 ASSEMBLY DETAIL

84926



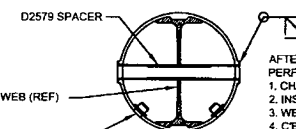
DETAIL A
SCALE 1:4



DETAIL B
SCALE 1:4

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SECTION C-C
SCALE 1:4

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

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APPROVED	PH	TITLE	SCALE
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries